

# Work Order ID 50724

July 21, 2009 12:41:56 PM



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Item ID: D2017-121

Accept



Setup Start



Revision ID: E

Stop



Item Name: Step Strut

Start Date: 7/06/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/06/09 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev. Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2017

Rev F

PK →

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 09/09/10

(X2)

110

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:15am

FINISH TIME:

4000F

⇒ 09/09/14

(V2)

Ø

120

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-09-14

②

W/O: 50724		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.09.09	90	Punch tube as per Dwg. & Deben	SP	09/09/08			
			M-L	09/09/10	(2x)		

Part No: D2017-121 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 50724

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Item Name: Step Strut

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Required Date: 7/06/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 132

0.00



Packaging

Memo

0.00

Packaging

9/9/14

SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/15

Bl 09-9-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Status	Item ID	Rev	Name	Start Date	Quantity	PeJOMp Date	Secrap ap	Qua	mmeind	N	C	ILCX	I	Sortme	Offse	an	Ty1	Per	Och	to	lore	Ce	Last	Id	Da
✓	M304TR0.750W.049		304 RD Tube .750...	6/24/09	1.0500	f		100	5	0.0...				1	0	M...							6/3...	6/...	

# Picklist Print

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Page 1

Work Order ID: 50724

Parent Item: D2017-121RevE

Parent Item Name: Step Strut

Comments:

Start Date: 7/06/09

Required Date: 7/06/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No				f	350.2300	2.1000			



304 RD Tube .750 x .049W

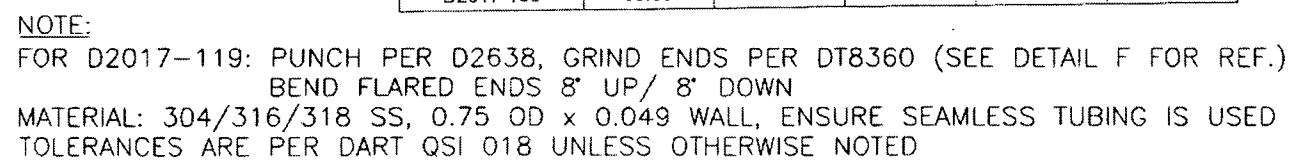
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	350.2300026	
107518	7.27	
108498	0	
109314	8.5	
110113	0.73	
110271	0.03	
111096	9	
111457	11.43	
111619	13.2700026	
112187	300	

3.000

88 09/09/09

ORIGINAL COPY ISSUED

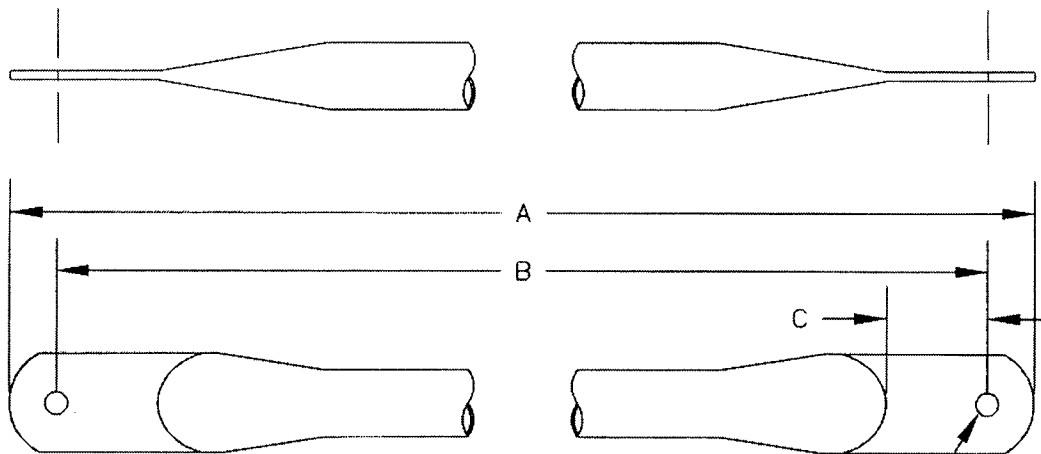
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
BW	11		
CHECKED	APPROVED	DRAWING NO.	REV. E
HE	TH	D2017	SHEET 1 OF 2
DATE		TITLE	SCALE
99.04.16		STEP STRUTS	NTS
C	95.01.26	ADDED PARTS	
D	96.03.28	ADD PARTS	
E	99.04.16	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897)	
E1	2-1	ADD TUNING	





DESIGN	BW	DRAWN BY	11	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	<i>KE</i>	APPROVED	<i>KE</i>		DRAWING NO. D2017
DATE	99.04.16			TITLE	SCALE
				STEP STRUTS	NIS

RELEASED  
DATE 11 KE



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

*50724*

NOTE:

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FIG. H FINISH COAT WHITE (435 L) PER DART QSI 018 435 L